

Work Order ID 63178

Friday, October 22, 2010 10:52:36 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 10/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



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Item Name: Replacement Float Skidtube

Start Date: 10/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



HandFinishing

Hand Finish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 ☐ 1115114
Expiry date: ☐ 11/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☐ 1115114
Expiry date: ☐ 11/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.
A/R ☐ LPS Procyon ☐ 1114596

1 0 11/03/02

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Page 3

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Stop



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Start Date: 10/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/02

④

Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

PM 63177

C4/3/2④

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/02

MF

11-03-02

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Friday, October 22, 2010 10:52:40 AM



Page 1

1000

FOUO - UNCLASSIFIED

Required Qty: 1.00

Comments: IPP Rev A□05.10.13□New Issue□ KJ/JLM□
 IPP Rev B□06.02.13□ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			110	Each	2,361.000	24	24		11/03/01	
				<u>Location</u>									
				ST303				3					
					115438			3					
				ST350				2358		M116704	V22		
					114108			14					
					114416			12					
					114523			2					
					115300			330					
					115589			1000					
					115936			1000					
AN3C6A  BOLT		Purchased	No			110	Each	253.0000	12	12		11/03/01	
				<u>Location</u>									
				ST351				253					
					111982			253					

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Picklist Print

Friday, October 22, 2010 10:52:40 AM

Page 2

Work Order ID: 63178

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 10/22/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A

Purchased

No

110

Each

102.0000

8

8



BOLT



11/03/02

Location

Loc Qty

Loc Code

ST351

102

113149

81

114382

21

4

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

29.0000

44

44



washer



11/03/02

Location

Loc Qty

Loc Code

ST245

29

M116304

107534

29

38

D3391-021

Manufactured

No

110

Each

0.0000

1

1



Fwd Tube Assembly

B61664



(x1) 11/03/02

D3391-023

Manufactured

No

110

Each

1.0000

1

1



Mid Tube Assembly

B65986



(x1) 11/03/02

Location

Loc Qty

Loc Code

FP

1

40522

1

D3391-025

Manufactured

No

110

Each

1.0000

1

1



Aft Tube Assembly

B66011



(x1) 11/03/02

Location

Loc Qty

Loc Code

FP

1

48122

1

Friday, October 22, 2010 10:52:40 AM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 63178



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 10/22/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-1

Manufactured No

110

Each

13.0000

1

1



Wearshoe



HL 11/03/02 PTO=)

Location

Loc Qty

Loc Code

FG

2

33798

2

FP19

11

58823

11

D3564-3

Manufactured No

110

Each

8.0000

1

1



Wearshoe



HL 11/03/02 PTO=)

Location

Loc Qty

Loc Code

FG

2

33764

2

FP19

6

55489

1

58825

5

D3564-5

Manufactured No

110

Each

19.0000

1

1



Wearshoe



HL 11/03/02

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

5

57525

1

58709

1

61699

3

FP-19

13

62237

13

B65523

xi

Friday, October 22, 2010 10:52:40 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/03/02	110	Assemble with wearplate D4095-041 / B66501	JSL	11/03/02	x1	11.03.02		
11/03/02	110	Assemble with wearplate D4095-043 / B66502	JSL	11/03/02	x1	11.03.02		

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Page 4

Work Order ID: 63178

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 10/22/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1



Gasket



Manufactured No

110 Each

23.0000

2

2



Handwritten: n/A

Location

Loc Qty

Loc Code

FP015

23

57715

2

61992

1

62892

20

D3566-5



Gasket

Manufactured No

110 Each

17.0000

1

1



Handwritten: 10/10/02

Location

Loc Qty

Loc Code

FP

5

60869

5

FP015

12

62463

12

Handwritten: 366146

Handwritten: 21

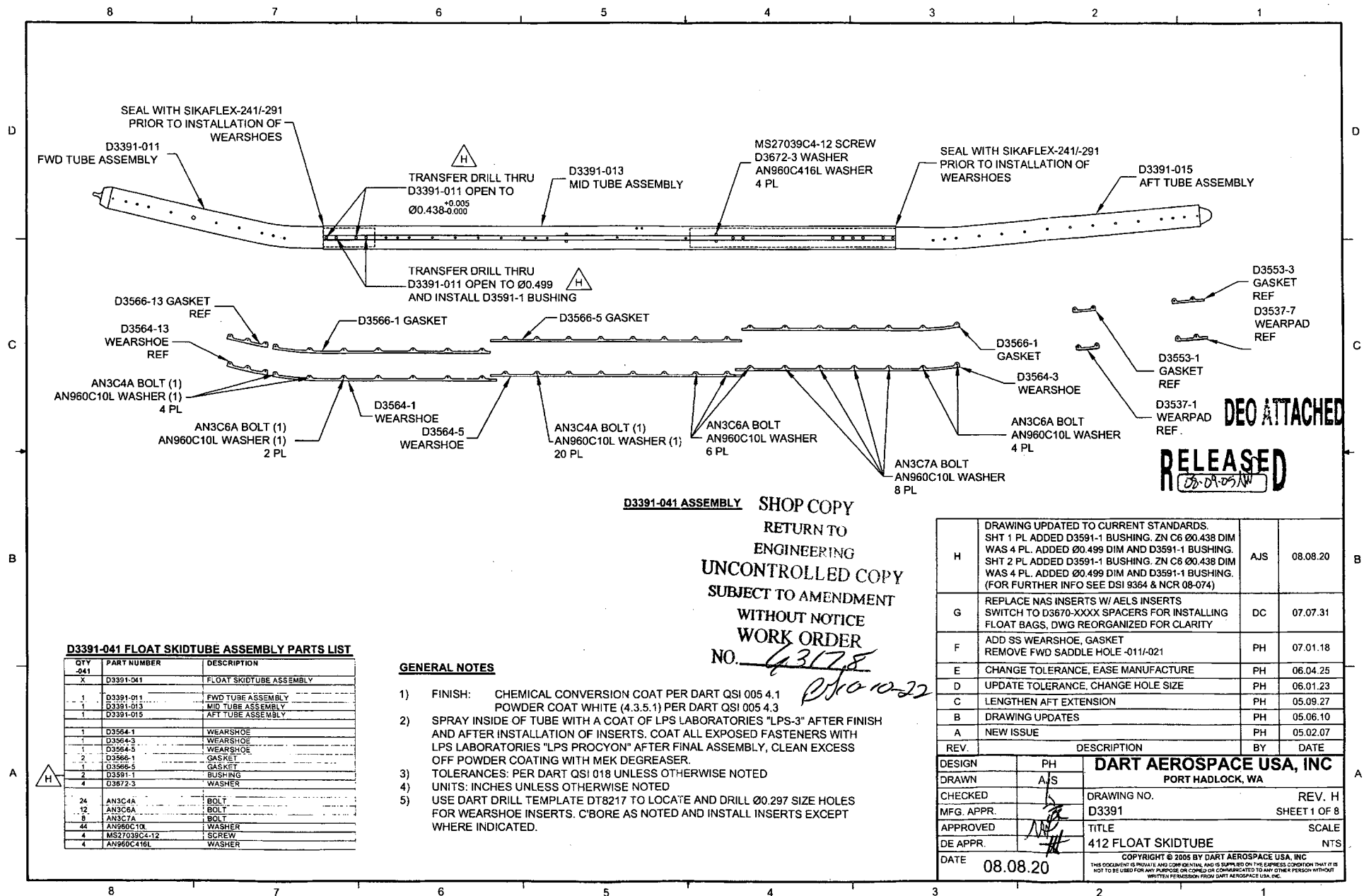
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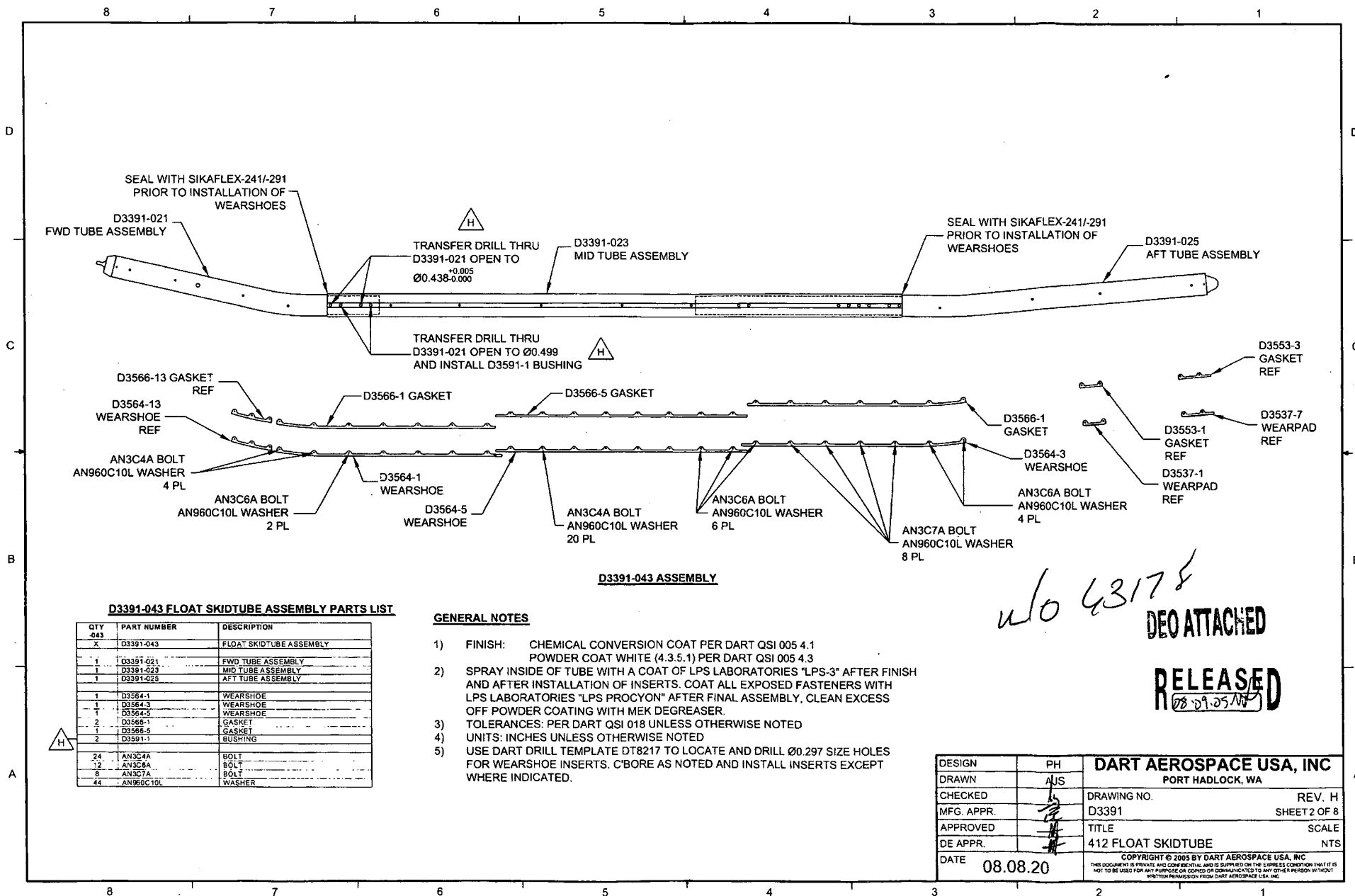
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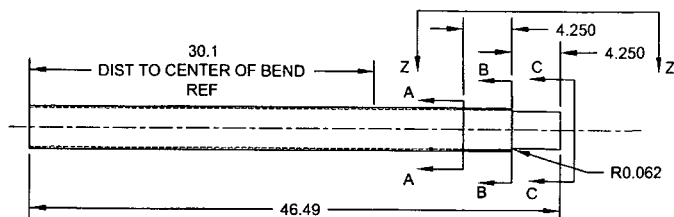
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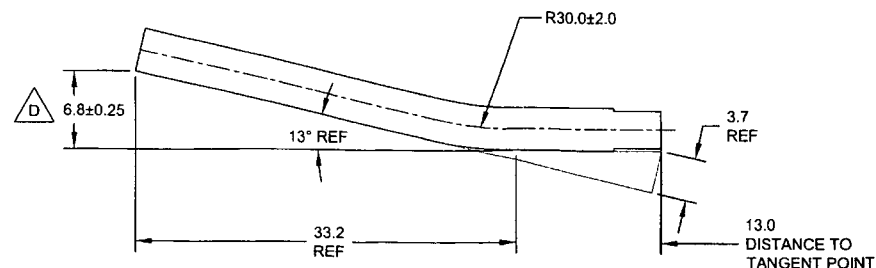
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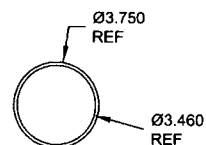
NOTE: Date & initial all entries



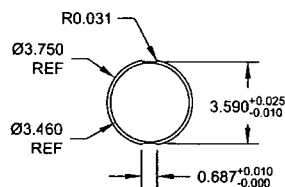
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



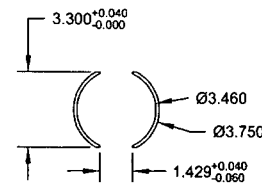
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



SECTION A-A
SCALE 2X

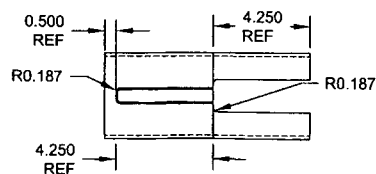


SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

W6 43178



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28-05-10

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.		TITLE 412 FLOAT SKIDTUBE	SHEET 3 OF 8
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
DATE	08.08.20	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

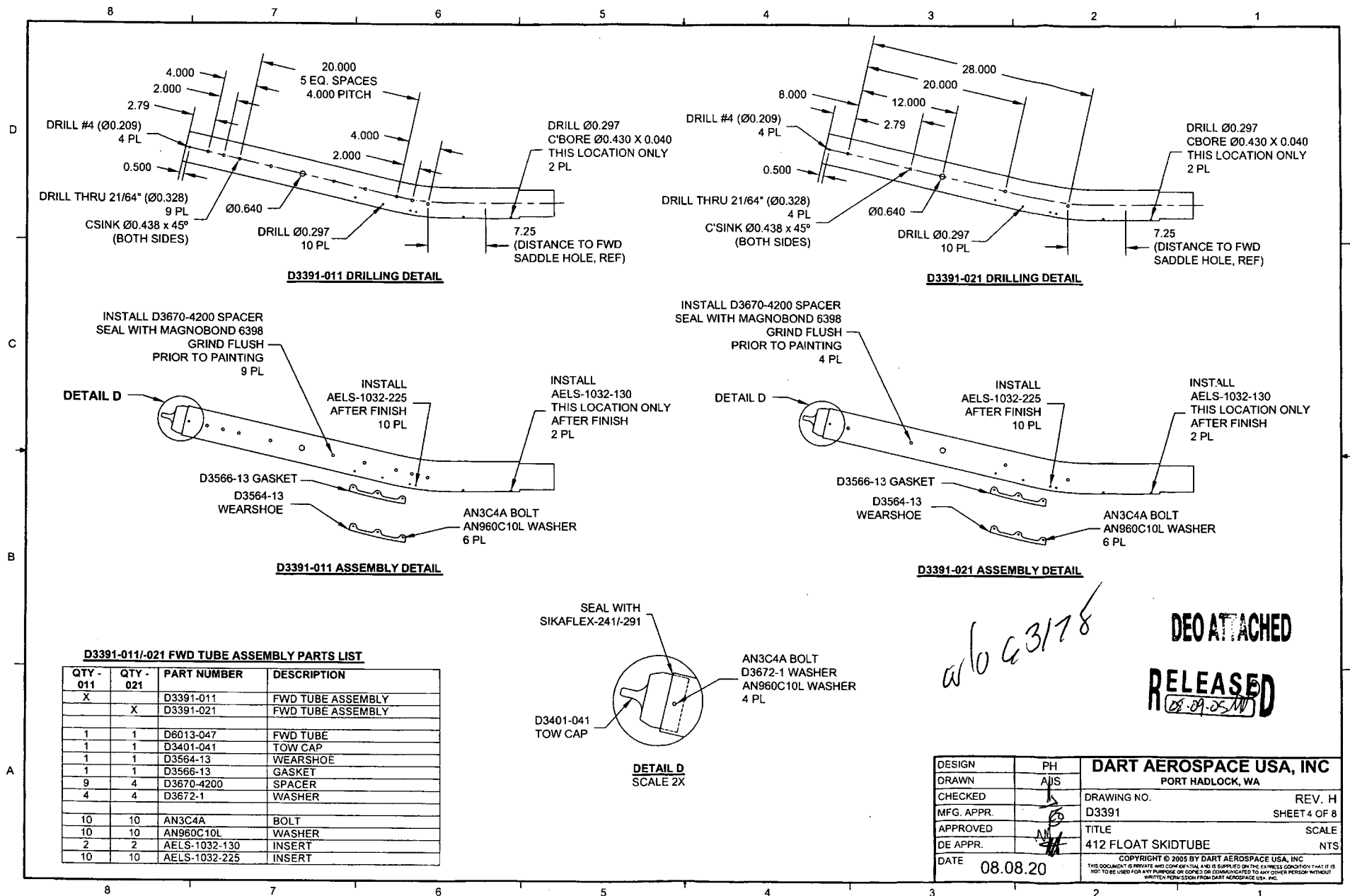
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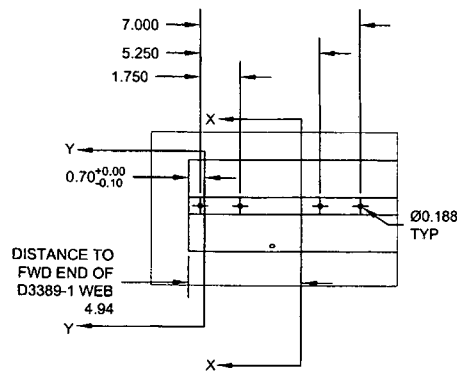
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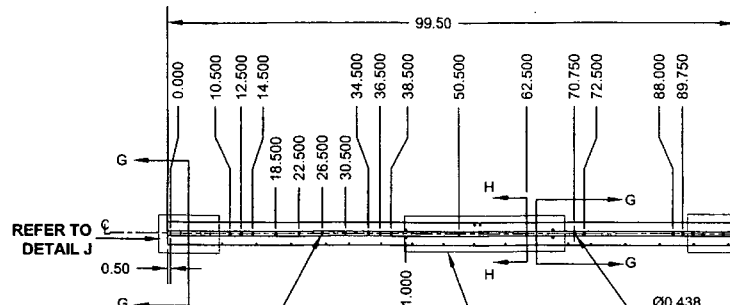
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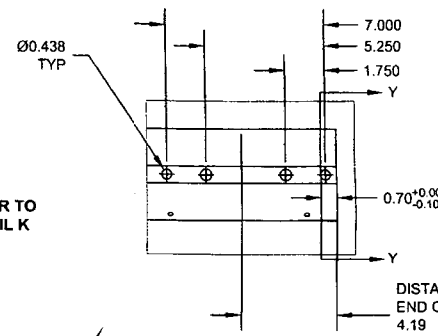


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



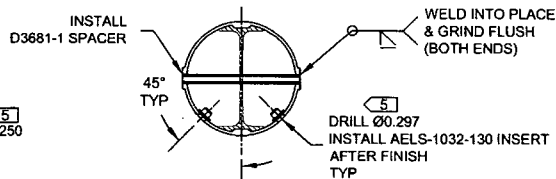
D3391-013 ASSEMBLY DETAIL



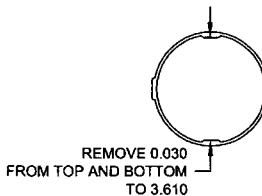
DETAIL K
SCALE 4X



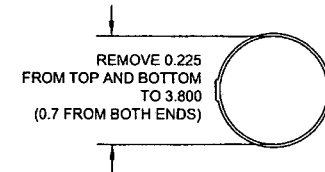
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



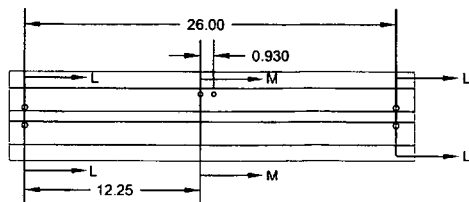
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

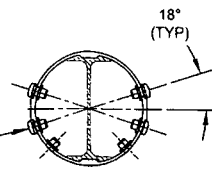
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

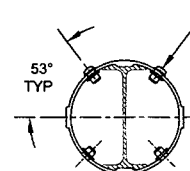


DETAIL E
SCALE NONE

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL

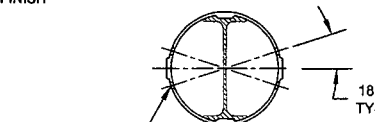


SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X

DEO ATTACHED

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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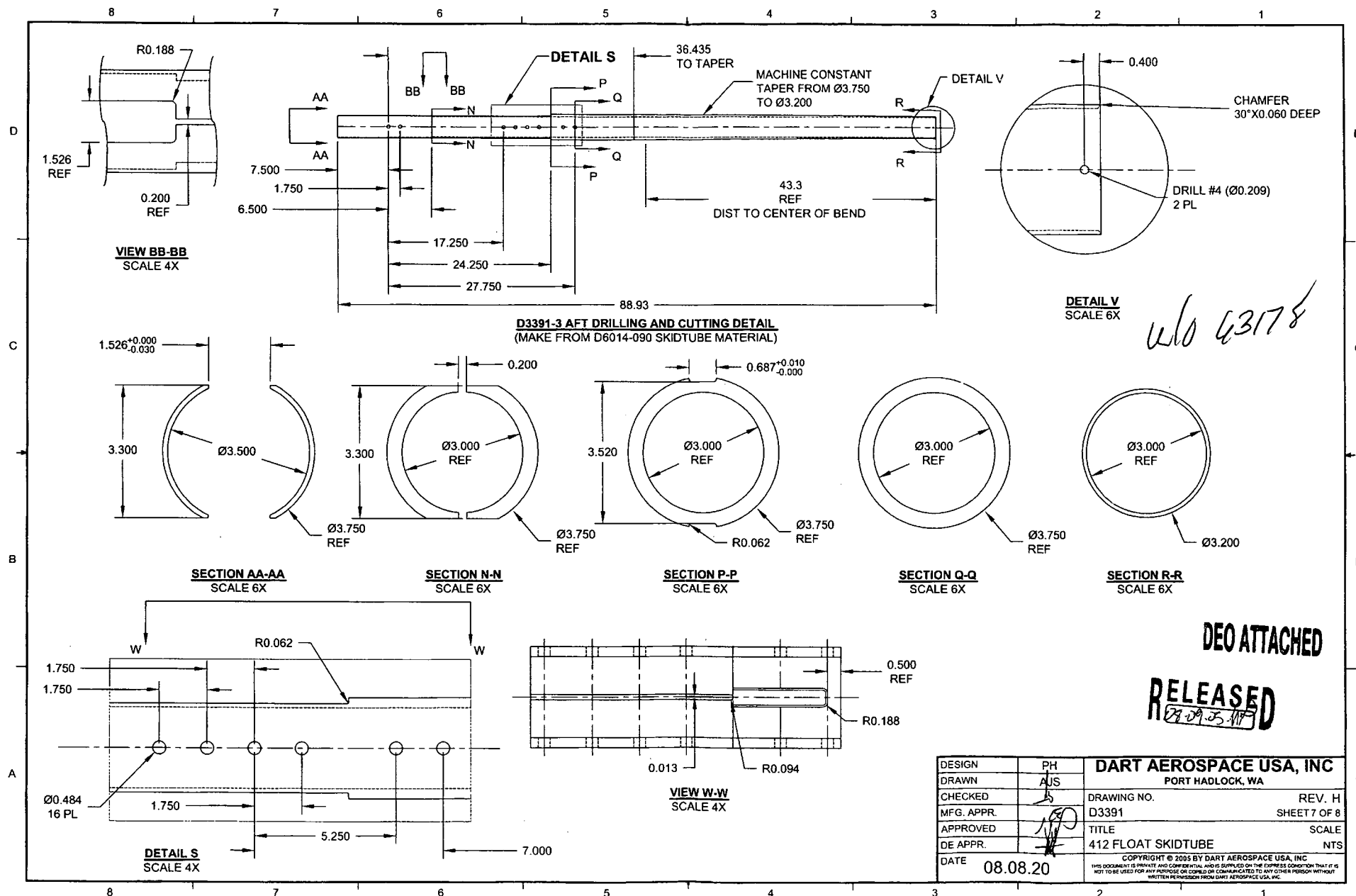
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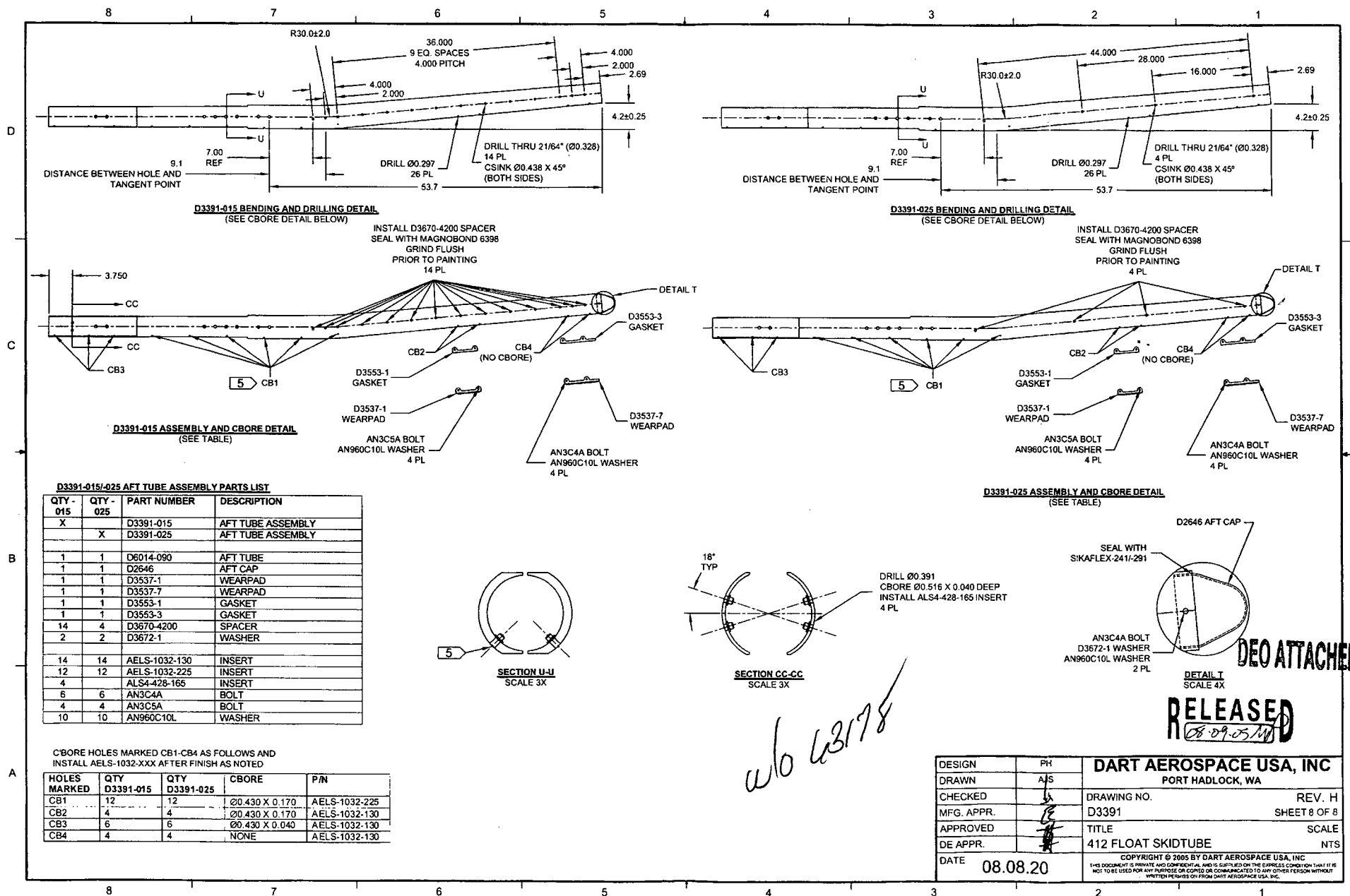
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE <i>04.09.24</i>	DATE <i>09/09/25</i>	DATE <i>09/09/30</i>		DATE <i>09/09/30</i>		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/o 43/18

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37
REF. FAA STC: SR01583SE
REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ONLY

PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations. The new DSI-9517-011 Wearplate Kit consists of new wearplates and gaskets destined to replace existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

INSTALLATION PROCEDURE:

Replace D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets with D4095-041/-043 Wearplates Assemblies as follows:

1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It might be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
4. Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
6. Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742. Torque to 15-25 in-lbs (1.7-2.8 N-m).
8. Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
9. Amend weight and balance per the Weight and Balance Table below.

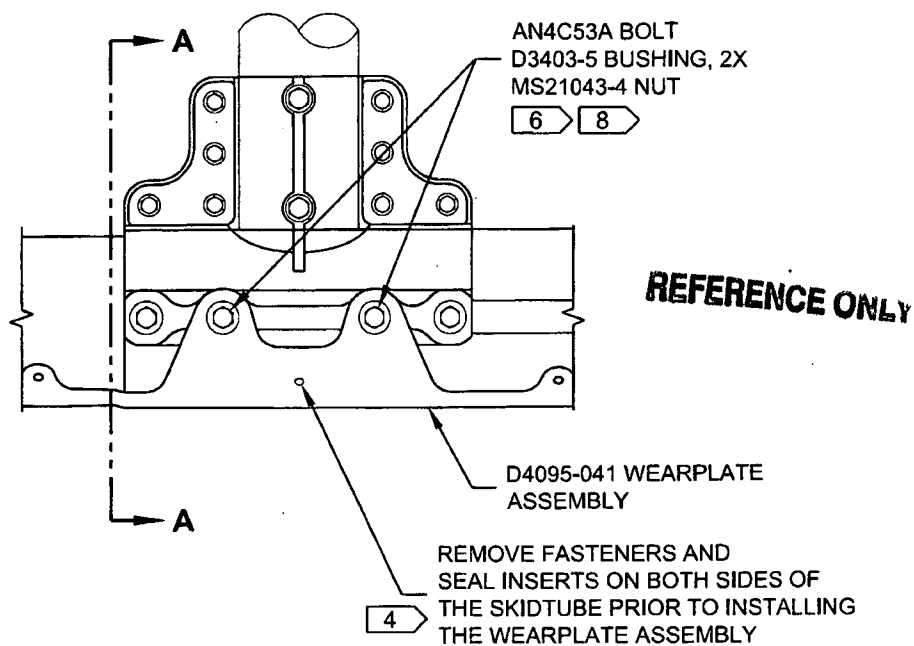
WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

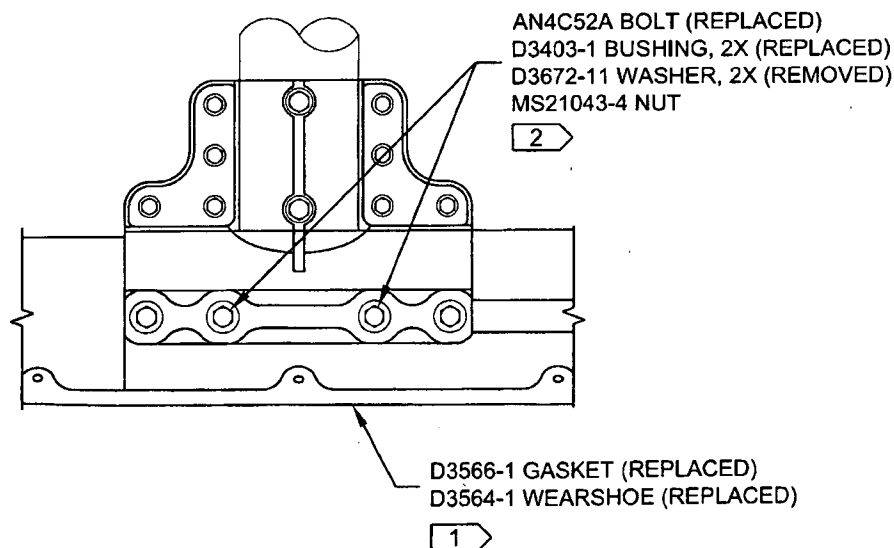
INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D412-742-011 Float Skidtube Installation with DSI-9517-011 Kit Installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg
D412-742-013 Float Skidtube Installation with DSI-9517-011 Kit Installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg

A	NEW ISSUE	MB	10.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9517	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
DATE	10.04.21	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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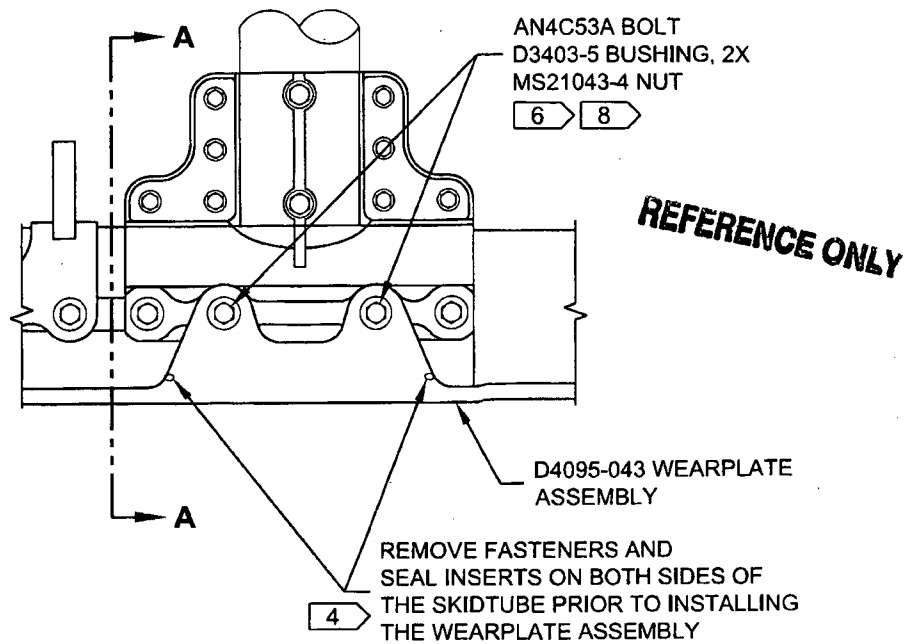
WAS:



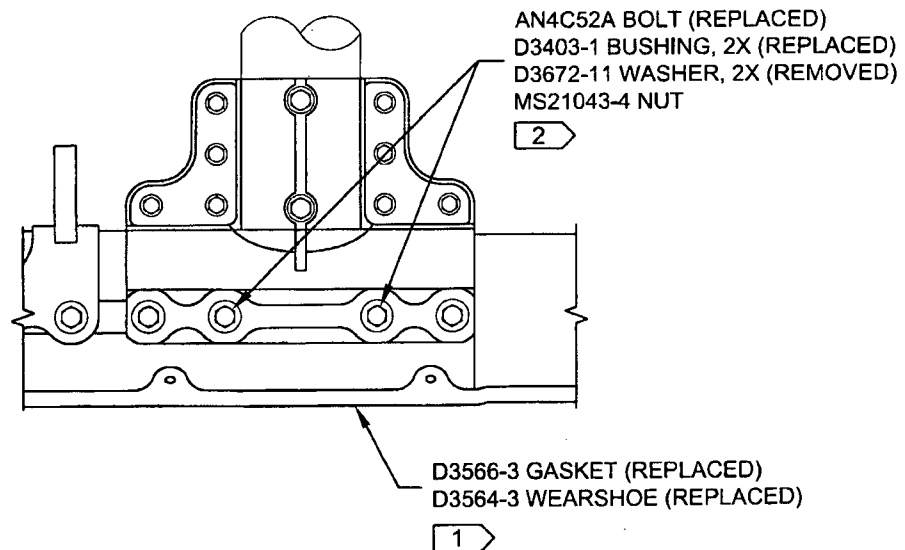
**FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9517	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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IS:

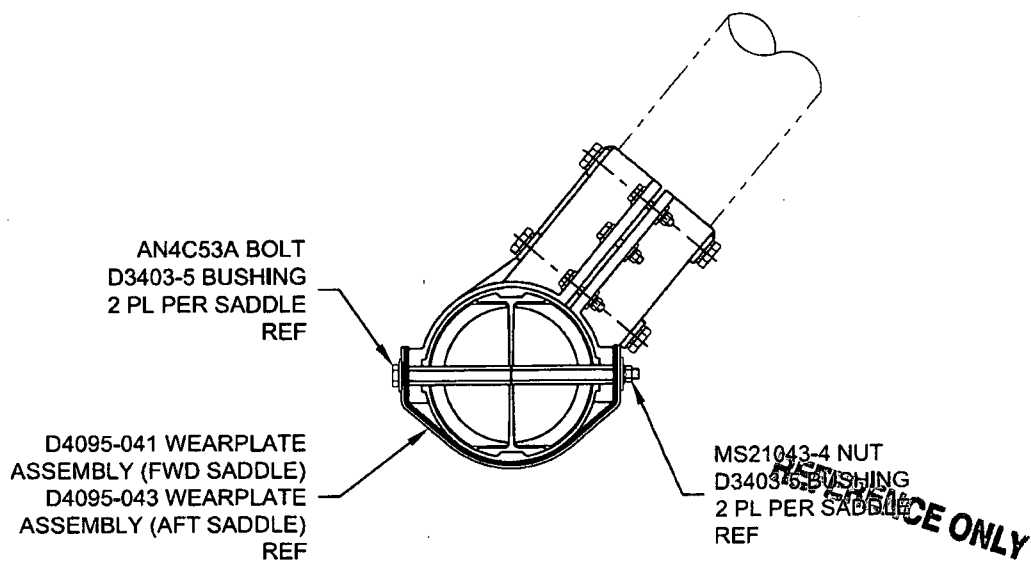


WAS:



**FIGURE 2: CHANGE AT AFT SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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DSI-9517-011 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9517	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)

21A		1		D4095-041	WEARPLATE ASSEMBLY
21B		*1		*D4096-1 (PART OF D4095-041)	*GASKET (BONDED TO D4095-041, REPLACES D3566-1)
22A		1		D4095-043	WEARPLATE ASSEMBLY
22B		*1		*D4096-3 (PART OF D4095-043)	*GASKET (BONDED TO D4095-043, REPLACES D3566-3)

46	8			D3403-1	BUSHING (REPLACES QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)

49	4			AN4C52A	BOLT (REPLACES QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)

53	8			D3672-11	WASHER (REMOVED QTY.8)
----	---	--	--	----------	------------------------

WAS:

3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER

21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET

46	16			D3403-1	BUSHING
----	----	--	--	---------	---------

49	8			AN4C52A	BOLT
----	---	--	--	---------	------

53	16			D3672-11	WASHER
----	----	--	--	----------	--------

*BONDING IS ACHIEVED USING 3M 1300/ 1300L SCOTCH GRIP ADHESIVE.

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CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9517	SHEET 5 OF 6
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	ALTERNATE WEARPLATE KIT	NTS
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THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

3		10	AN3C6A	BOLT (REMOVED QTY.2)
4		4	AN3C7A	BOLT (REMOVED QTY.4)
5		38	AN960C10L	WASHER (REMOVED QTY.6)

21A	1		D4095-041	WEARPLATE ASSEMBLY
21B	*1		*D4096-1 (PART OF D4095-041)	*GASKET (BONDED TO D4095-041, REPLACES D3566-1)
22A	1		D4095-043	WEARPLATE ASSEMBLY
22B	*1		*D4096-3 (PART OF D4095-043)	*GASKET (BONDED TO D4095-043, REPLACES D3566-3)

46	8		D3403-1	BUSHING (REPLACES QTY.4 WITH D3403-5)
46A	8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)

49	4		AN4C52A	BOLT (REPLACES QTY.4 WITH AN4C53A)
49A	4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)

53	8		D3672-11	WASHER (REMOVED QTY.8)
----	---	--	----------	------------------------

WAS:

3		12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER

21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET

46	16		D3403-1	BUSHING
----	----	--	---------	---------

49	8		AN4C52A	BOLT
----	---	--	---------	------

53	16		D3672-11	WASHER
----	----	--	----------	--------

*BONDING IS ACHIEVED USING 3M 1300/ 1300L SCOTCH GRIP ADHESIVE.

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MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6
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